

CARBO B 10

International standards	EN 499	E 42 4 B 42 H5
	AWS A 5.1	E 7018

Approvals TÜV, DB, GL, Ü, UDT

Typical applications and characteristics CARBO B 10 is a universal basic coated electrode for welding highly stressed joints with high security. Resistant to cold cracks - easy slag removal.
Very good welding characteristics - can also be used in constrained welding positions. Fast solidifying weld metal - allows position welding at high amperage.

Operating temperature From -40° C up to +450° C

Base materials

DIN EN 10025	S235JRG1, S235JRG2, S235JRG3, S275JR, S275J2G3, S355J2G3
DIN EN 10028-2	P235GH, P265GH, P295GH, P355GH
DIN EN 10028-3	P275N, P275NH, P275NL2, P355N, P355NH, P420NL1
DIN 17100	St 37-2, St 44-2, St 52-3, ST 50-2
DIN 17175	St 35.8, St 45.8, 17 Mn 4, 19 Mn 5
DIN 17102	StE 255 – StE 420, WStE 255 – WStE 420, TStE 255 – TStE 420
DIN 17172	StE 210. 7 – StE 415.7 TM
DIN 17155	H I, HII, 17 Mn 4, 19 Mn 6

Shipbuilding steels: A - B - D - E; A36; D36; E36, F32, F36

Mechanical properties of all-weld metal
(typical values)

Tensile strength R_m N/mm ²	Yield strength R_{eL} N/mm ²	Elongation A_5 %	Impact strength ISO – V J - 40°C
530	> 420	> 22	> 47

Weld metal analysis
(typical, wt %)

C	Si	Mn
0.07	0.5	1.0

Current = +

Welding positions PA, PB, PC, PD, PE, PF,

Rebaking 1 h, 350° C +/- 10° C (if necessary) 1 h, 400° C = < 5ml hydrogen

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg / 1000	kg / packet	kg / carton
2.5 x 350	80 - 110	208	832	21,6	4,5	18,0
3.2 x 350	110 - 150	123	492	36,6	4,5	18,0
3.2 x 450	110 - 150	112	346	48,9	5,5	16,5
4.0 x 350	140 - 200	86	257	56,0	4,8	14,0
4.0 x 450	140 - 200	81	324	74,0	6,0	24,0
5.0 x 450	200 - 260	53	212	113,0	6,0	24,0